

# Work Order ID 52677

October 7, 2009 8:11:13 AM



Page 1

Item ID: D3846-3

Accept



Setup Start



Revision ID: B

Item Name: GASKET

Stop



Start Date: 10/09/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3846	B								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	1-Cut as per Dwg D3848								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	Memo	0.00							

MAT NOT pulled

13 9-10-10

6

13 9-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52677

October 7, 2009 8:11:13 AM



Page 2

Item ID: D3846-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 10/09/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

27.8 Oct 10/03



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: FINISHING 0.00

0.00

Packaging

Memo

Packaging

Per 10/13 (E)

140

QC21- Final Inspection - Work Order Release 0.00

0.00

QC

Memo

Quality Control

09/10/19 H

W 10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 7, 2009 8:11:12 AM

Work Order ID: 52677

Parent Item: D3846-3RevB

Parent Item Name: GASKET

Comments:

Start Date: 10/09/09

Required Date: 10/16/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	61.6034	4.6463			



NEOPRENE SHEET 0.063



13 9-10-10

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

61.60335853

111853

-4.147E-05

112508

61.6034

112866

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52677
<b>Description:</b> Gasket		<b>Part Number:</b>	D3846-3
<b>Inspection Dwg:</b> D3846	<b>Rev:</b> B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	300 X 300	*			
2.39	+/-0.030	2.399	*			
3.20	+/-0.030	3.202	*			
4.02	+/-0.030	4.028	*			
6.88	+/-0.030	6.75	*			
10.00	+/-0.030	10.00	x			
28.00	+/-0.030	28.00	*			
39.53	+/-0.030	39.53	*			
Ø0.219	+0.005/-0.001	0.221	*			
14.48	+/-0.030	14.48	*			
28.97	+/-0.030	28.97	*			
32.47	+/-0.030	32.47	*			
33.97	+/-0.030	33.97	*			
37.47	+/-0.030	37.47	*			
0.063	+/-0.010	0.057	*			

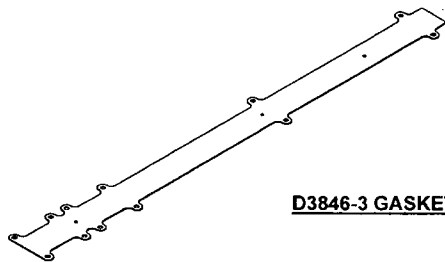
<b>Measured by:</b>	B	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	9-10-10	<b>Date:</b>	09/10/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	MA

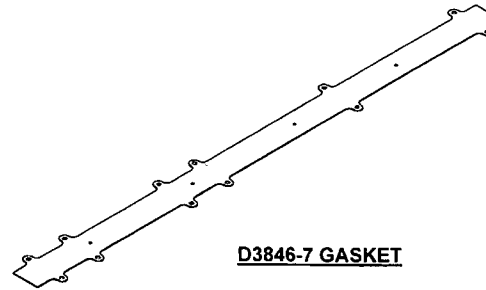
W/052677



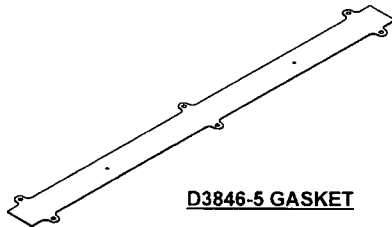
**D3846-1 GASKET**



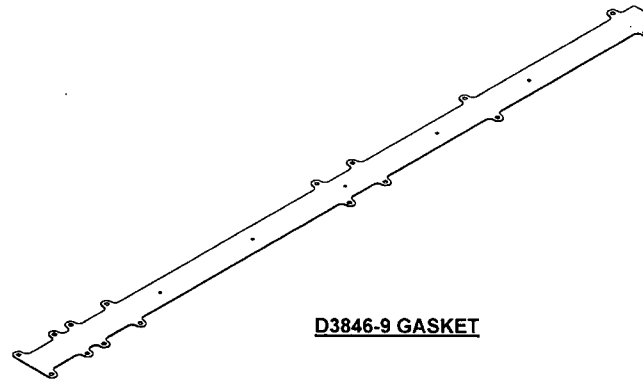
**D3846-3 GASKET**



**D3846-7 GASKET**



**D3846-5 GASKET**



**D3846-9 GASKET**



**D3846-11 GASKET**

**RELEASED**  
09/15/09

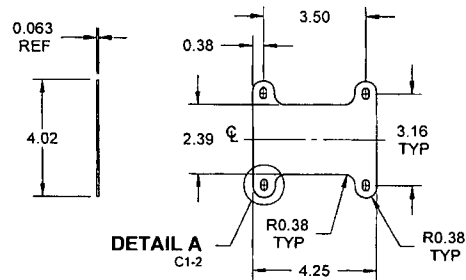
**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
  - D3846-1 = 0.03 lbs
  - D3846-3 = 0.25 lbs
  - D3846-5 = 0.20 lbs
  - D3846-7 = 0.26 lbs
  - D3846-9 = 0.35 lbs
  - D3846-11 = 0.04 lbs

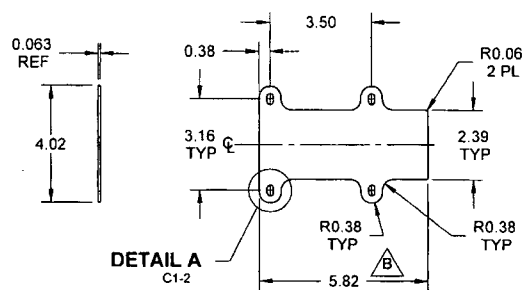
B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
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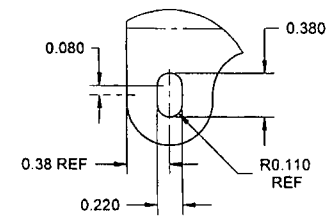
W/O 52677



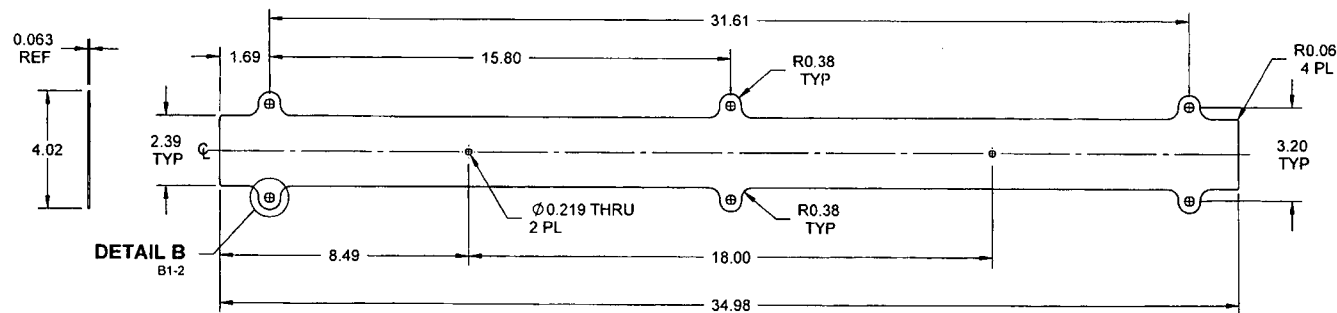
**D3846-1 GASKET**



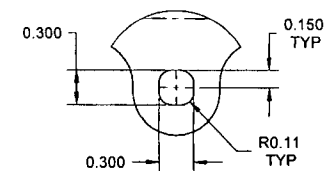
**D3846-11 GASKET**



**DETAIL A** C5-2  
TYP, SCALE 4X C7-2



**D3846-5 GASKET**

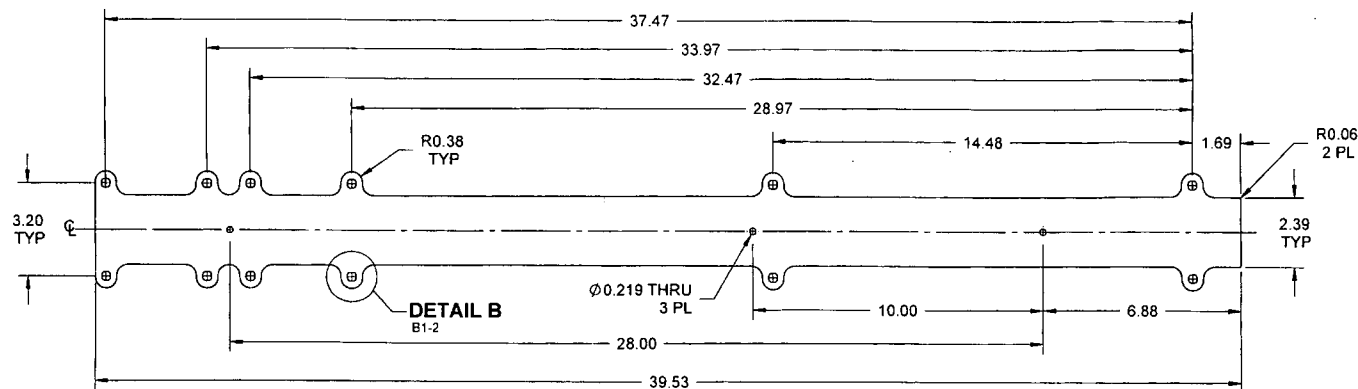
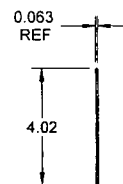


**DETAIL B** A7-2  
TYP, SCALE 4X C5-3  
C5-4 B7-3

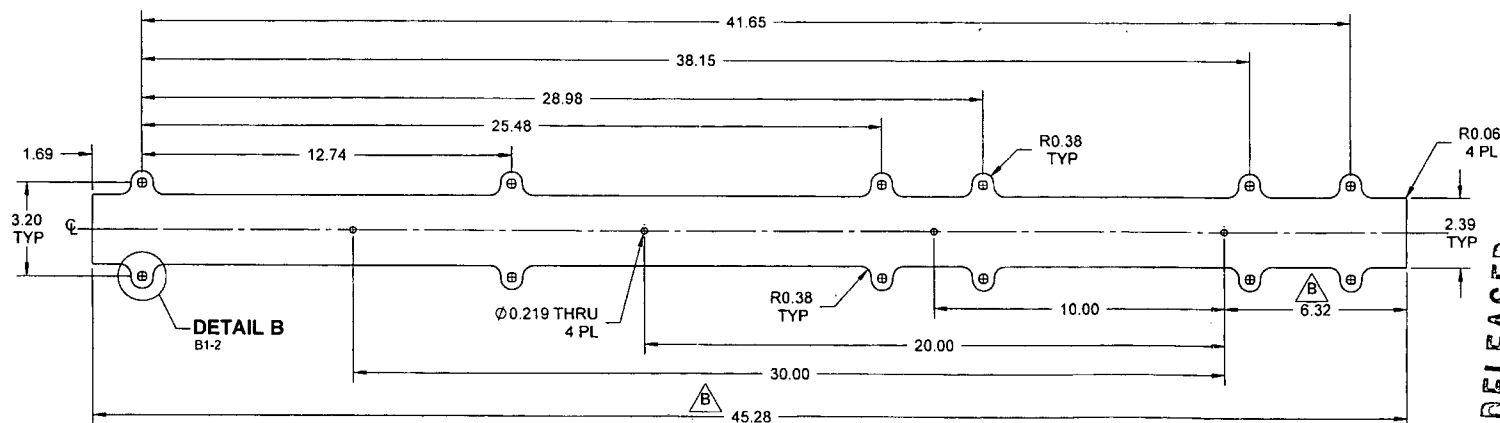
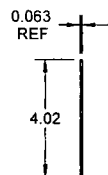
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09/01/15

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MFG. APPR.	<i>RF</i>	<b>D3846</b>	SHEET 2 OF 4
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w/o 52677



**D3846-3 GASKET**

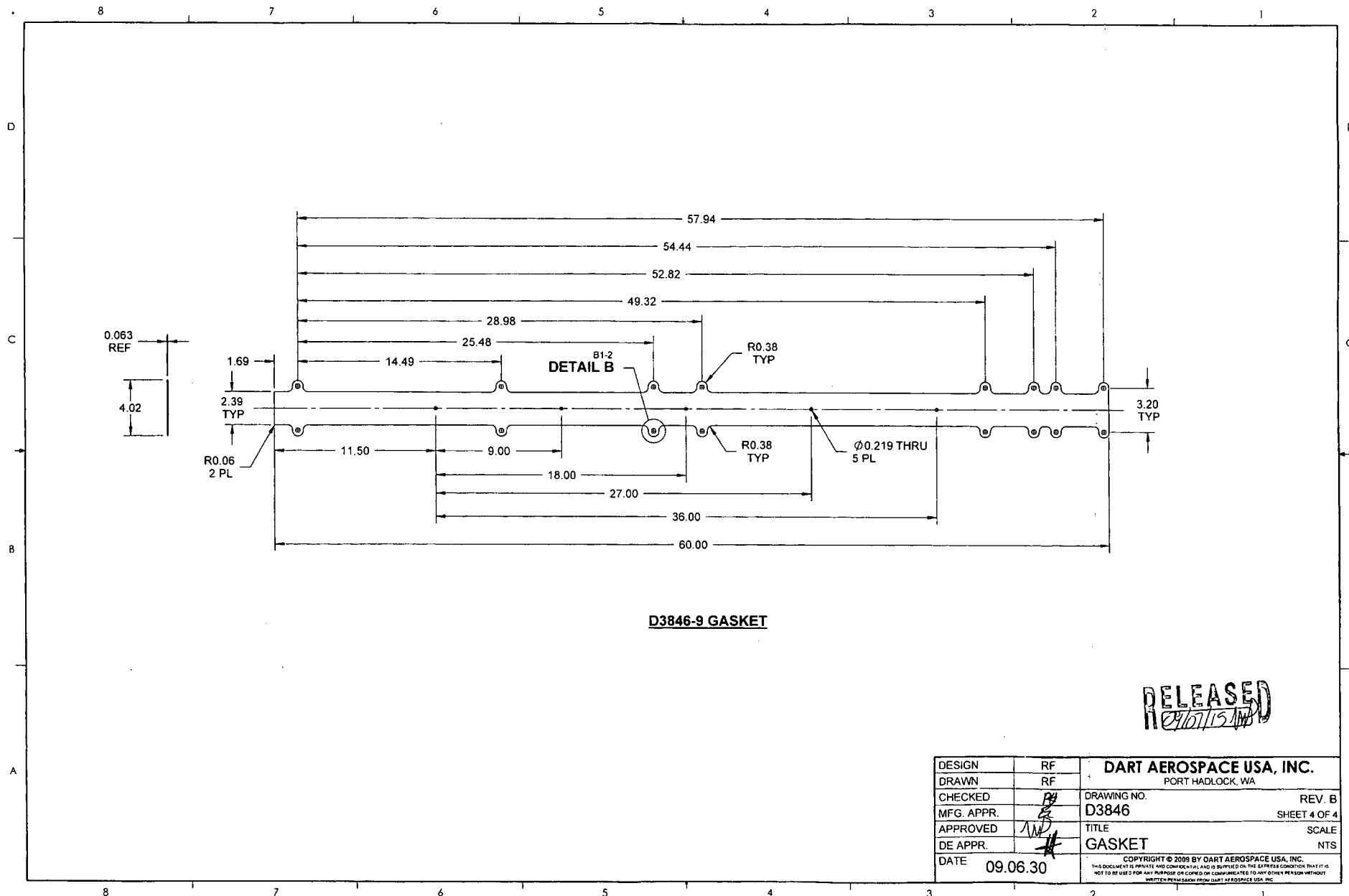


**D3846-7 GASKET**

RELEASED  
2/15/2000

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w/o 52677



**D3846-9 GASKET**

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02/07/15

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MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GASKET</b>	NTS
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